

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008063**Date Inspected:** 25-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi, Zhao Chen Sun.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

Bay 2 OBG Floor Beam

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT reports for this date. The members are identified as OBG Components. The weld designations reviewed are as follows.

FB011-029-004, 010, 013, 014, 022, 023

FB010-030-001, 009, 011, 012, 015, 016, 019, 020, 044

FB023-009-111, 132, 133, 136, 137, 130, 131, 067, 066, 054, 055, 065, 052, 053, 064, 063, 051, 050

Bay 6 OBG Cross Beam

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT reports for this date. The members are identified as OBG Components. The weld designations reviewed are as follows.

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CB202B-009-002
CB202B-009-001
CB202E-009-001
CB202E-009-002
CB202E-009-003

This Quality Assurance (QA) Inspector observed the following work in progress:

Bay 03

SMAW welding of weld joint 144 located on CB202G-025.
Welder is identified as 058102. ZPMC QC is identified as Mr. Yin Dong Hai.
The welding variables recorded by QC appeared to comply with WPS-B-P-2113.

FCAW welding of weld joint 141 located on CB202G-028.
Welder is identified as 208035. ZPMC QC is identified as Mr. Yin Dong Hai.
The welding variables recorded by QC appeared to comply with WPS-B-T-2132-3.

FCAW welding of weld joint 006 located on SSD10A-PP104.
Welder is identified as 044830. ZPMC QC is identified as Mr. Shi Lei.
The welding variables recorded by QC appeared to comply with WPS-B-T-2233-Tc-U4b-F.

FCAW welding of weld joint 014 located on CB202G-010.
Welder is identified as 044790. ZPMC QC is identified as Mr. Yin Dong Hai.
The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-U4b-F.

Bay 06

SMAW welding of weld joint 8B located on WD1-A307-77M-3.
Welder is identified as 066268. ZPMC QC is identified as Mr. Zhao Chen Sun.
The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1.

SAW welding of weld joint 001 located on CB202C-009.
Welder is identified as 054458. ZPMC QC is identified as Mr. Liu Chuan Gang.
The welding variables recorded by QC appeared to comply with WPS-B-T-2221-L2c-S-2

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang: 150-0042-2372, who represents the Office of Structural Materials for

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your project.

Inspected By: Gaikwad,Umesh

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer